

AKAS®- (LC) II M/F

CE

FIESSLER

ELEKTRONIK

Presentation of
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Product lines

General safety
problems of press
brakes

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Aspect for the
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Advantage for the
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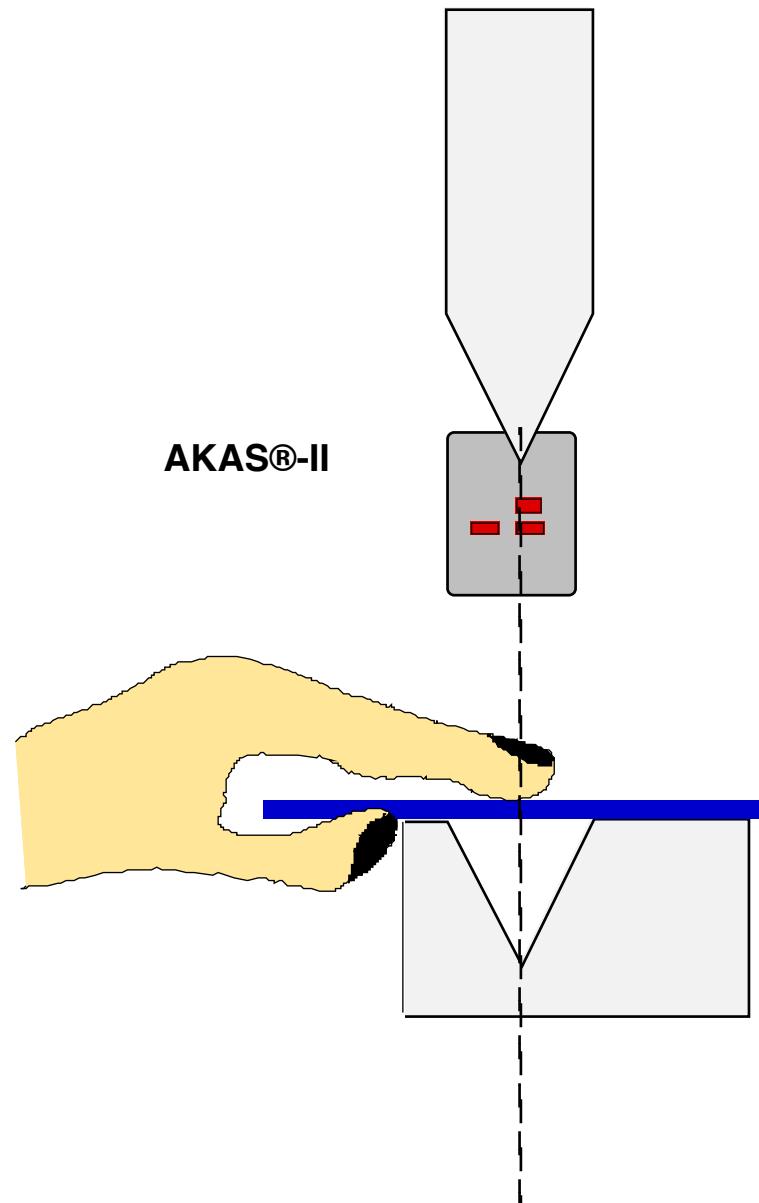
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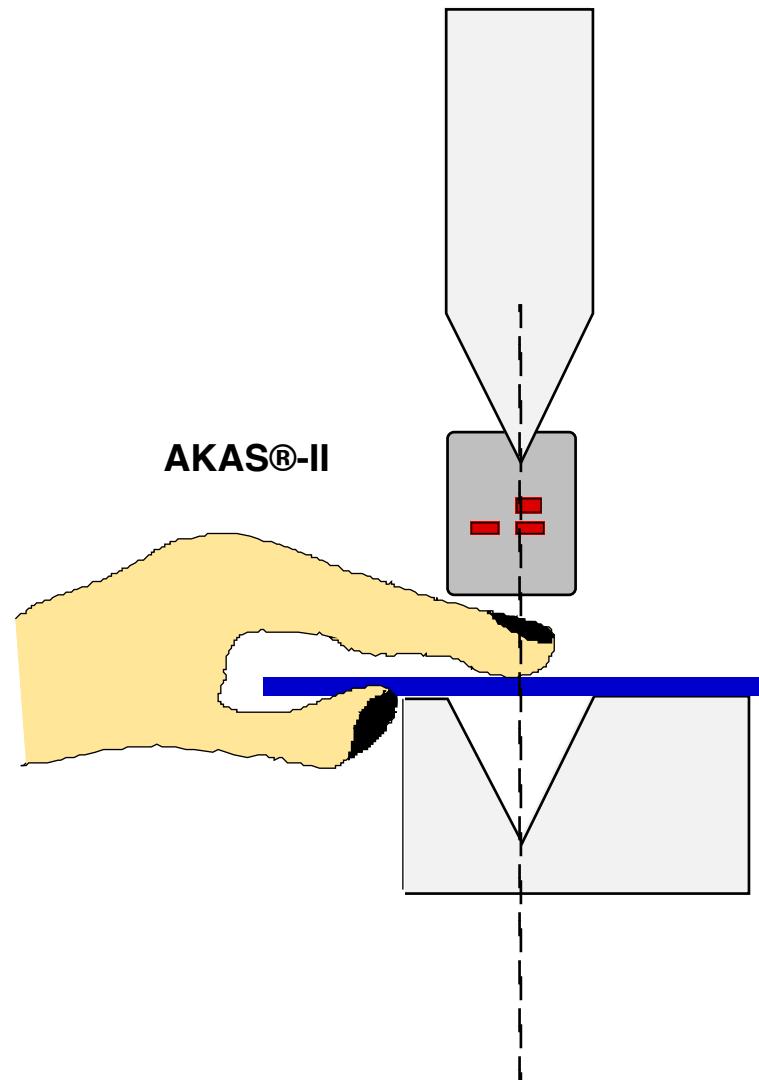
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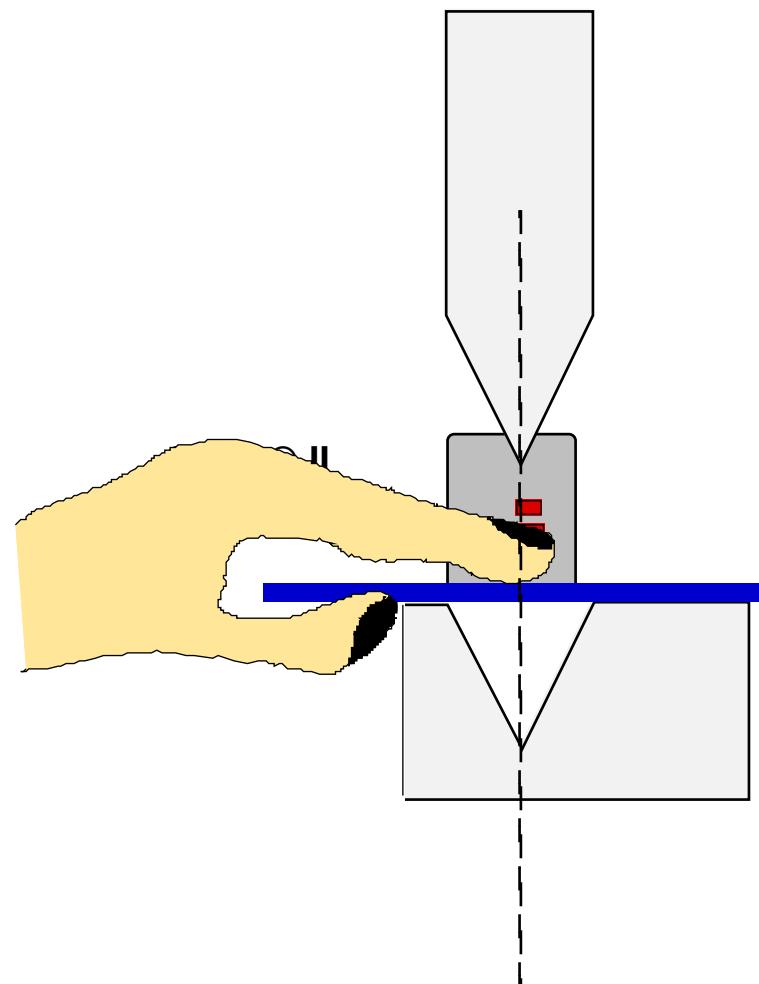
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Stop !



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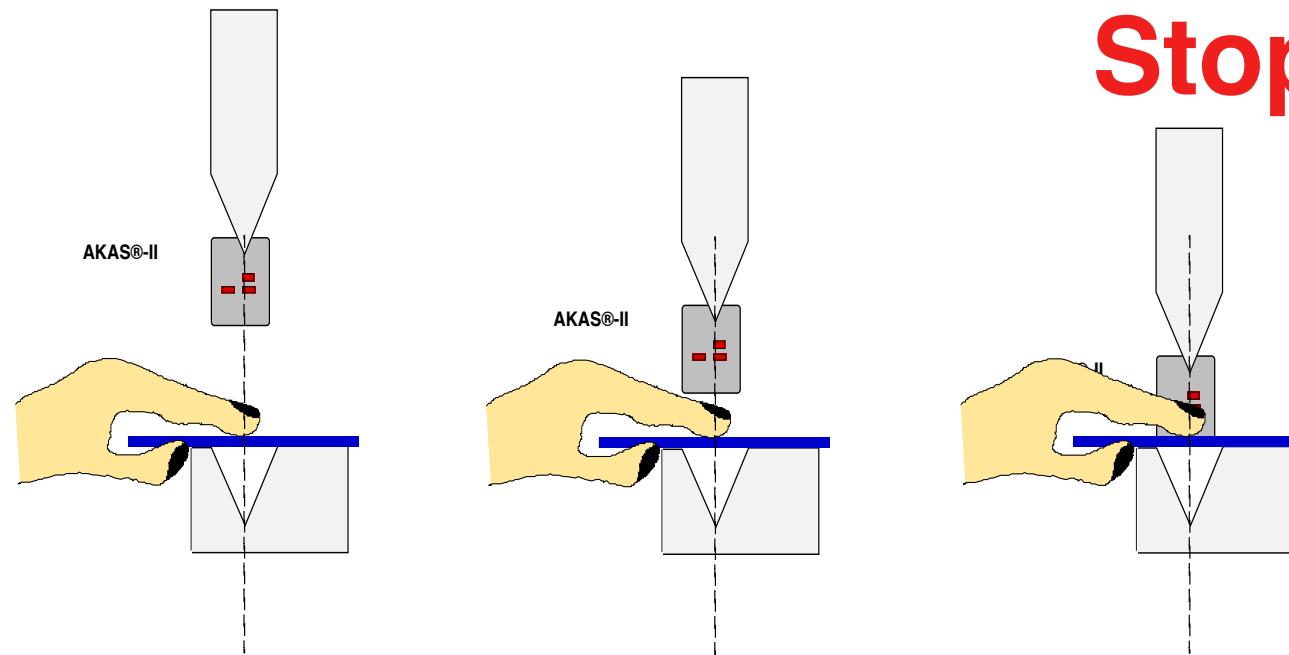
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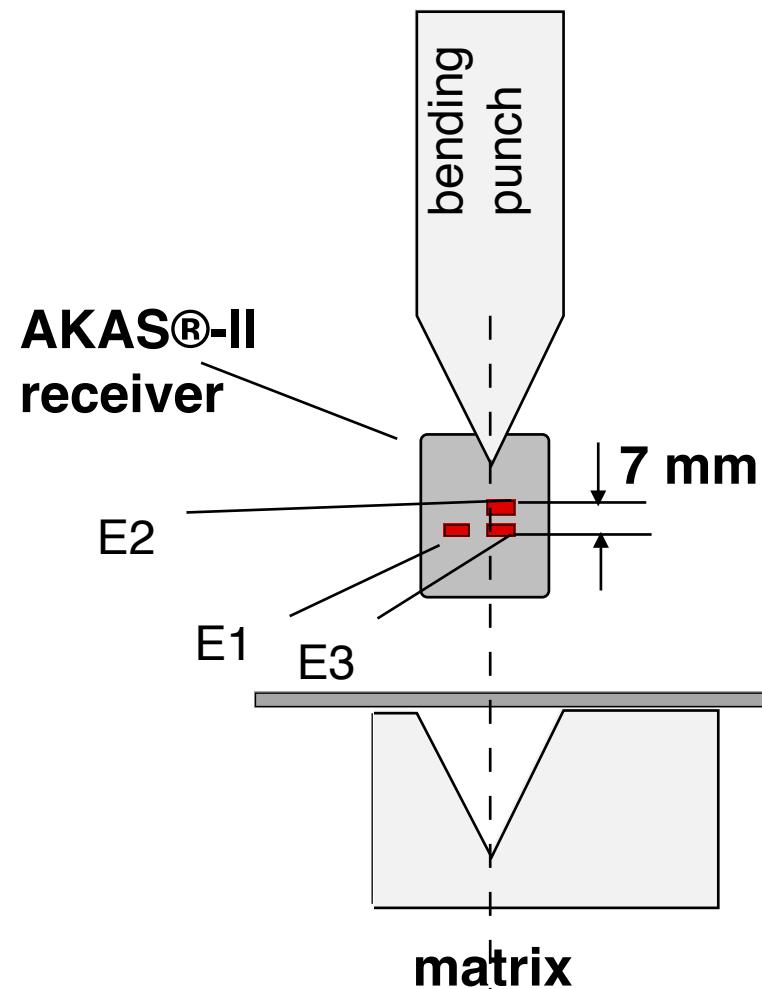
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closing movement



or



closing movement

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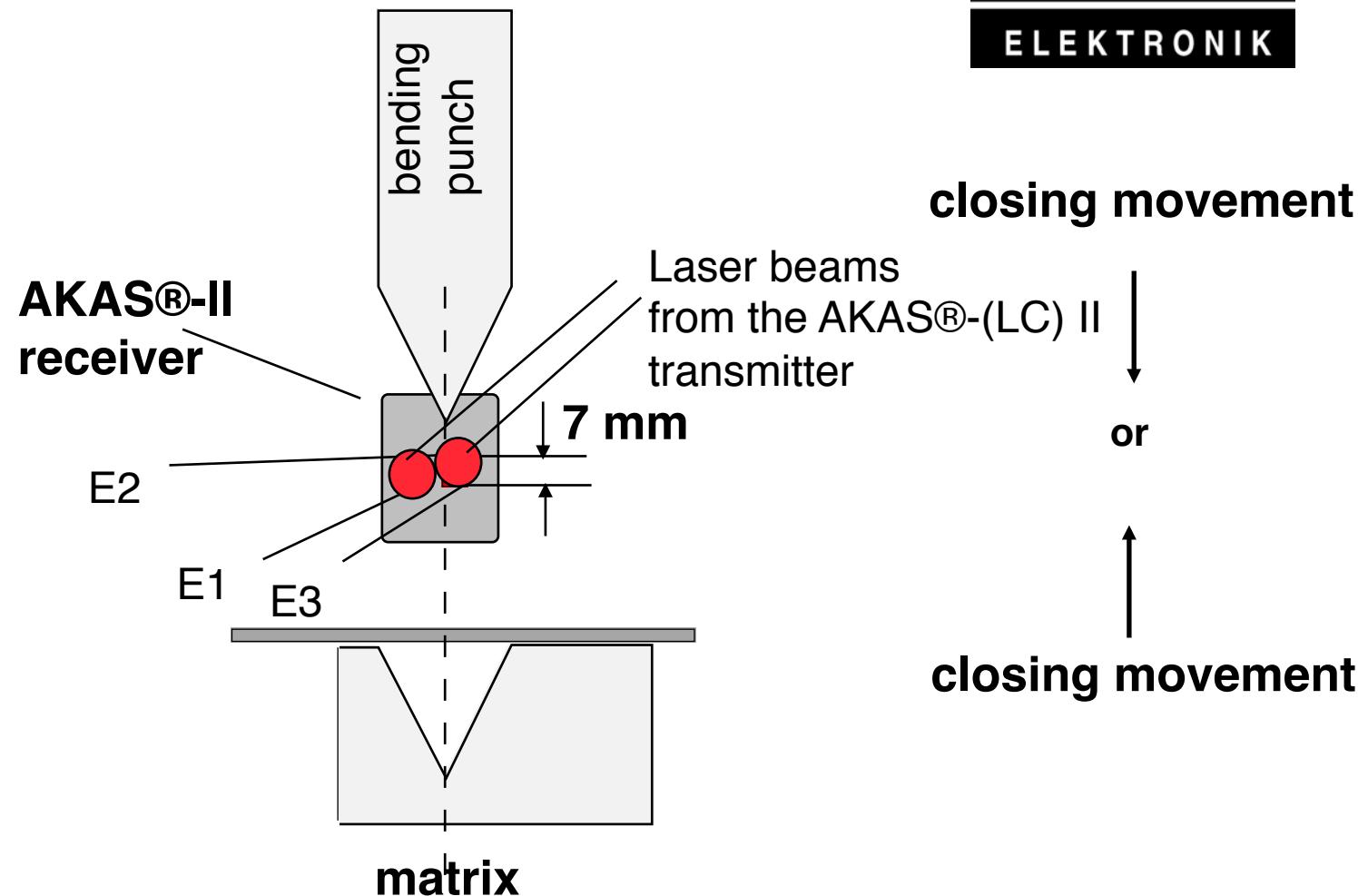
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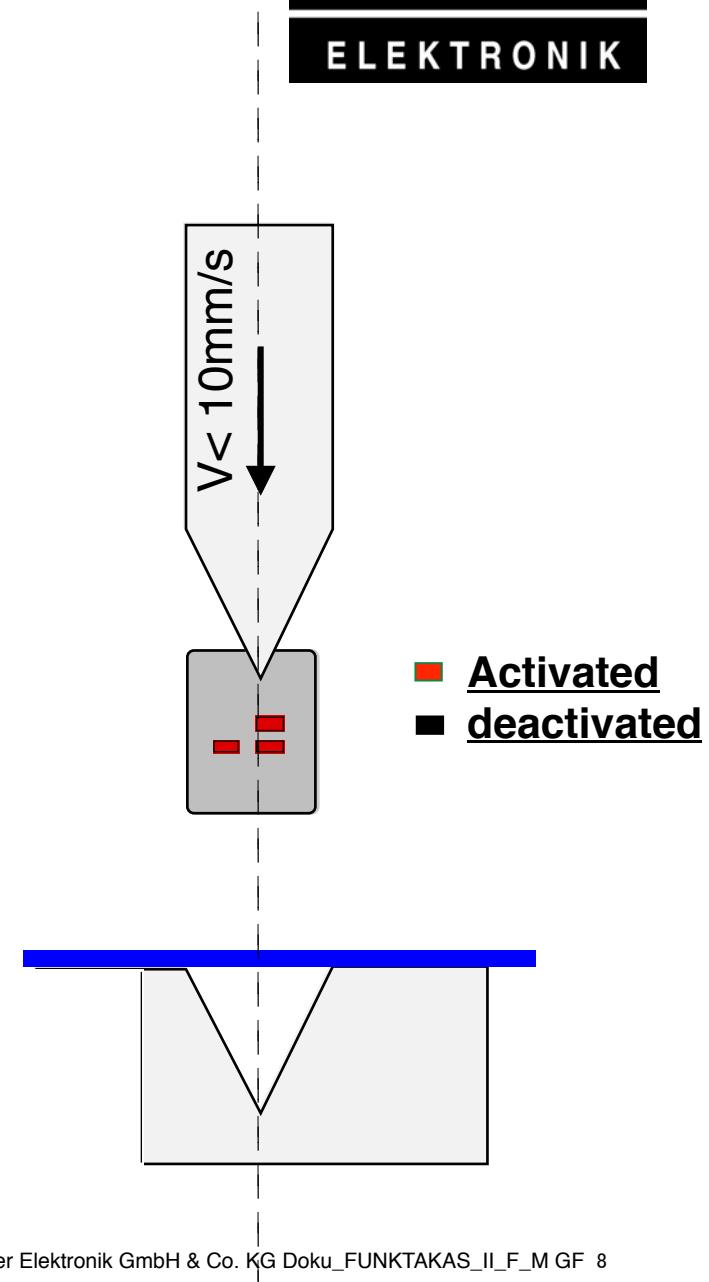
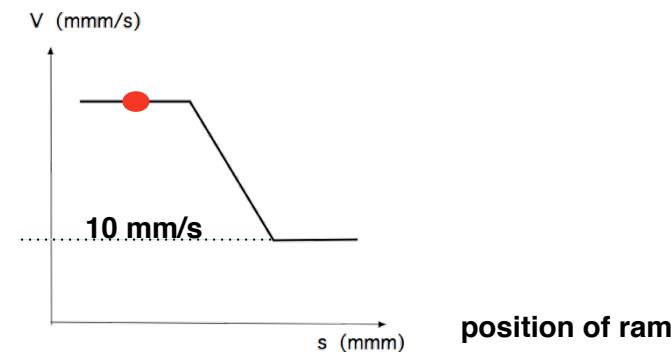
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- Start bending cycle with
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Speed of ram



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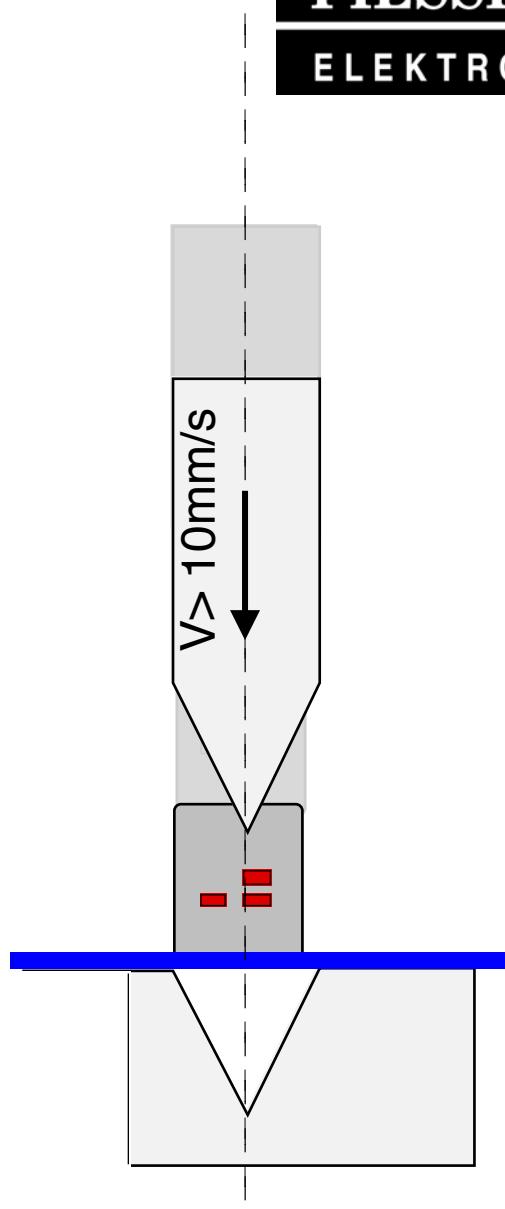
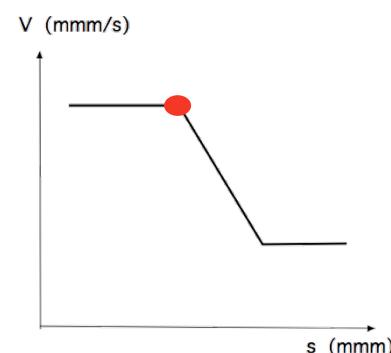
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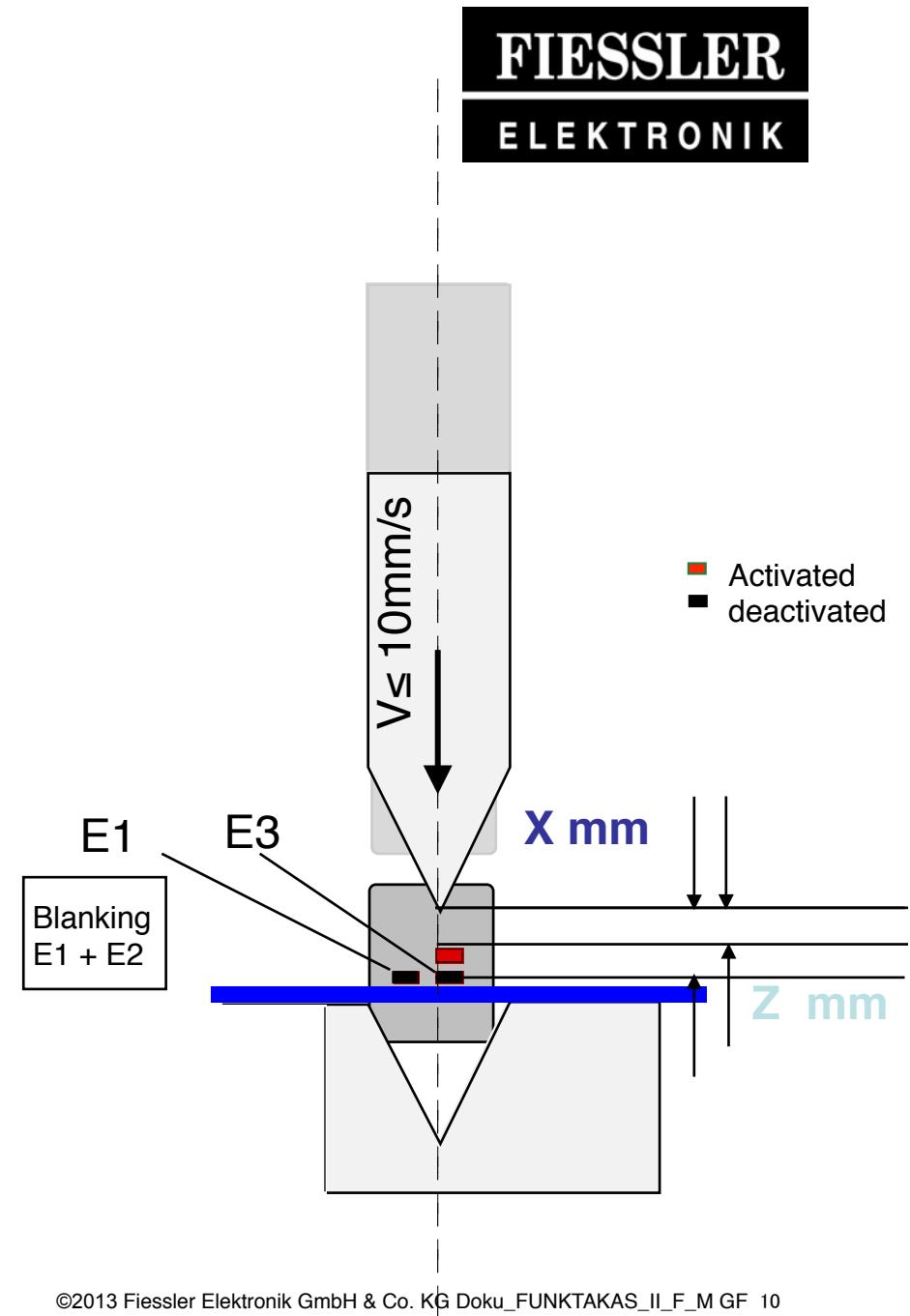
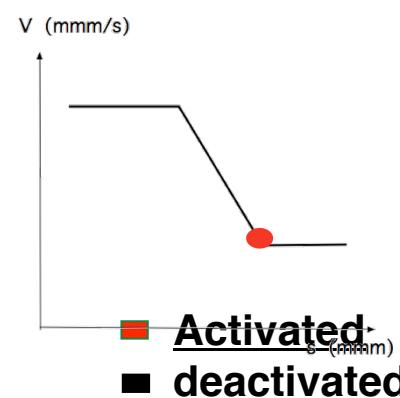
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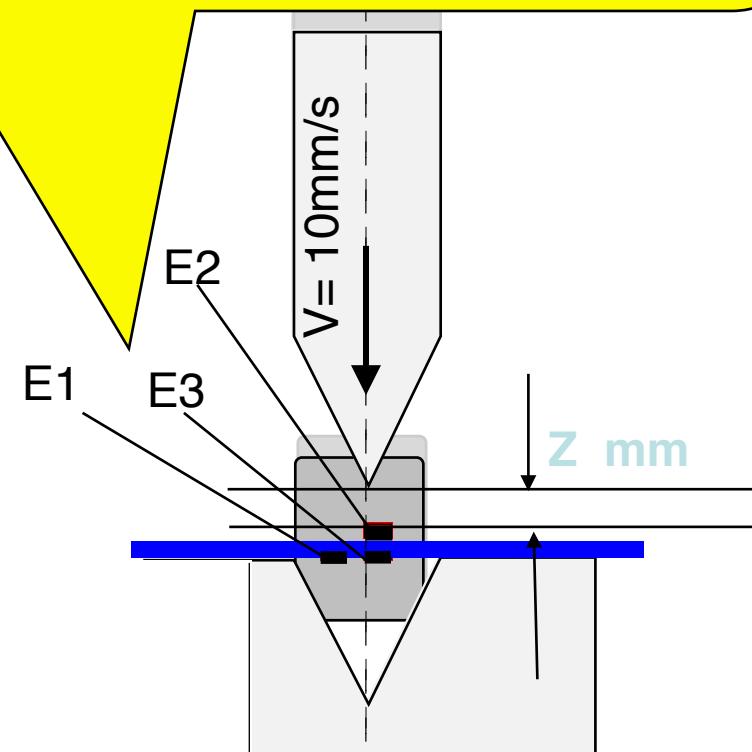


Depending of the max . overrun traverse of the press brake

AKAS®-II will go in complete Muting around distance Z + 2mm.

After this point the safety for the operator is provided by the slow speed which is monitored by the AKAS® system and the 3- position safety foot pedal (this is an additional protective measures according B11.3 that means also that the 3- position safety footpedal is a part of the AOPD according B11.3 8.7.7.1.3)

Distance Z after adjustment	Complete Muting point in inch	Max. overrun traverse during fast motion	X Slow speed point
9mm	0.43	10mm	18mm
8mm	0.39	9mm	17mm
7mm	0.35	8mm	16mm
6mm	0.31	7mm	15mm
5mm	0.28	6mm	14mm
4mm	0.24	5mm	13mm



Muting
E1, E2 +
E3

AKAS®-II



Depending of the max . overrun traverse of the press brake

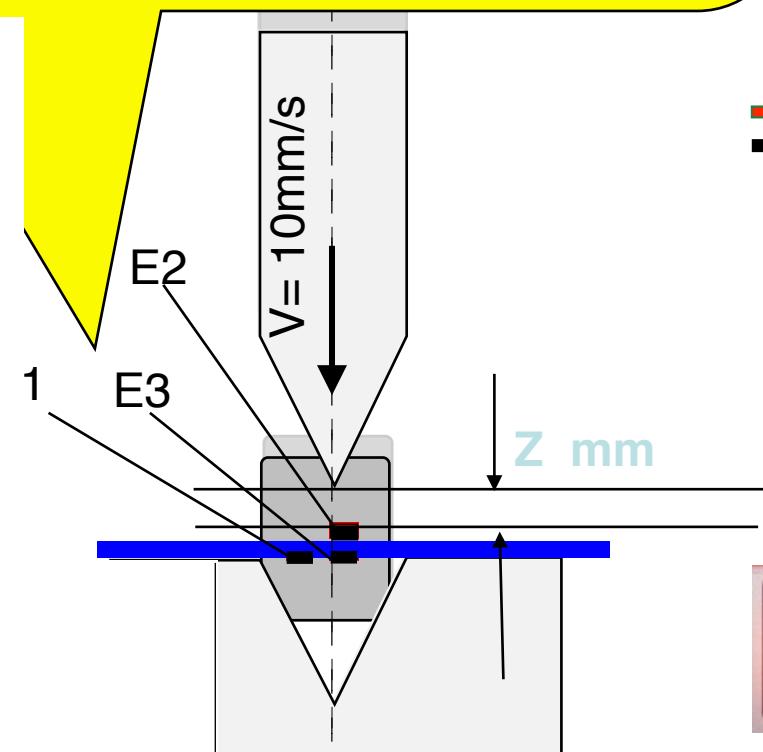
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8.7.7.1.3 The close proximity point of operation AOPD shall ensure that the tools can only close toward each other either:

- when the press brake is in high speed (more than 10 mm/sec [0.39 in/sec]) while the protection zone is functioning and capable of stopping the tool (within the prescribed limits) when an obstruction is detected, OR
- when the press brake is restricted to a safe speed (10 mm/sec or less [0.39 in/sec]) and used with additional risk reduction measures.

8mm	0.39	9mm	17mm
7mm	0.35	8mm	16mm
6mm	0.31	7mm	15mm
5mm	0.28	6mm	14mm
4mm	0.24	5mm	13mm



■ Activated
■ deactivated



Muting
E1, E2 +
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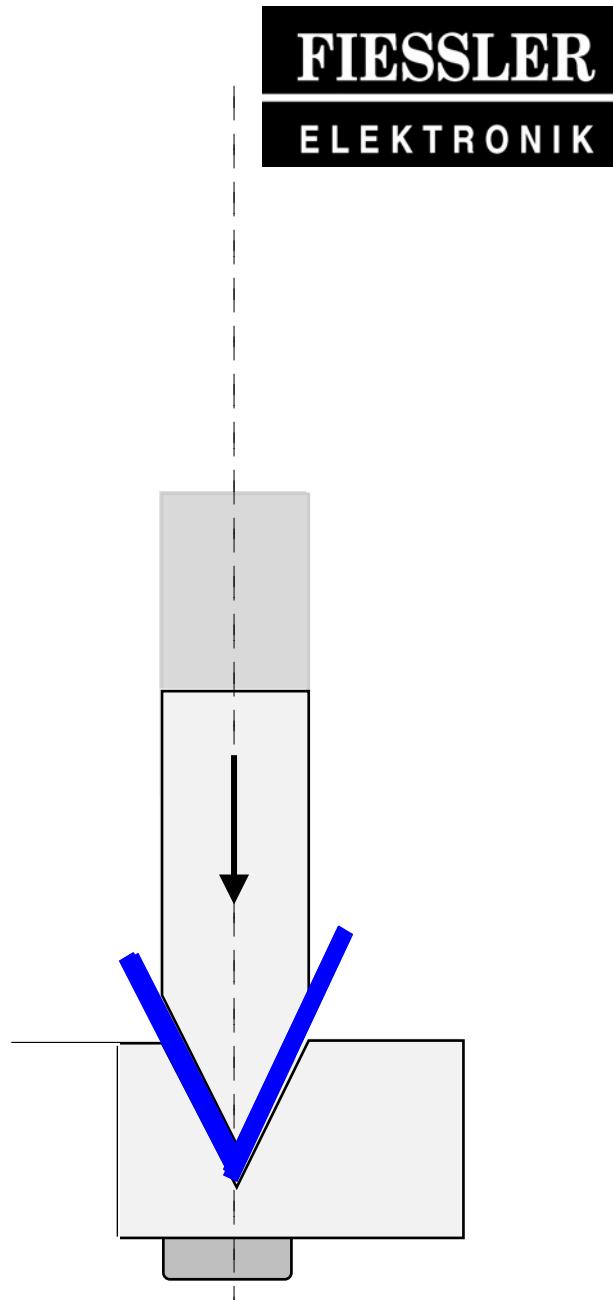
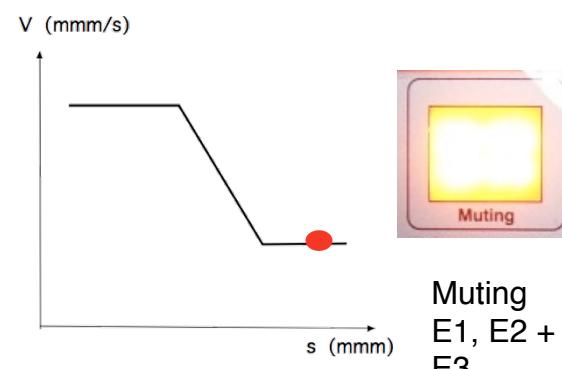
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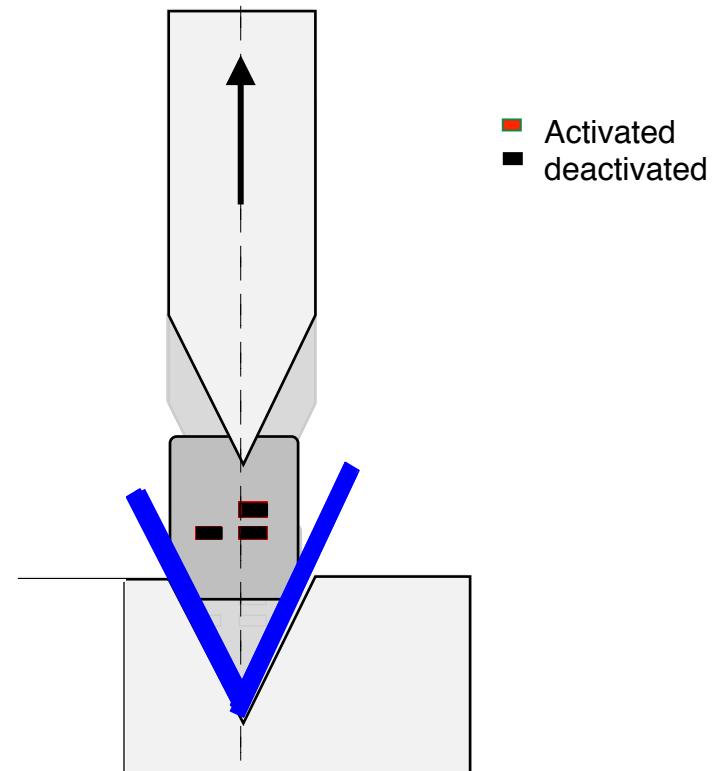
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“Pulse signal” (0-1-0)

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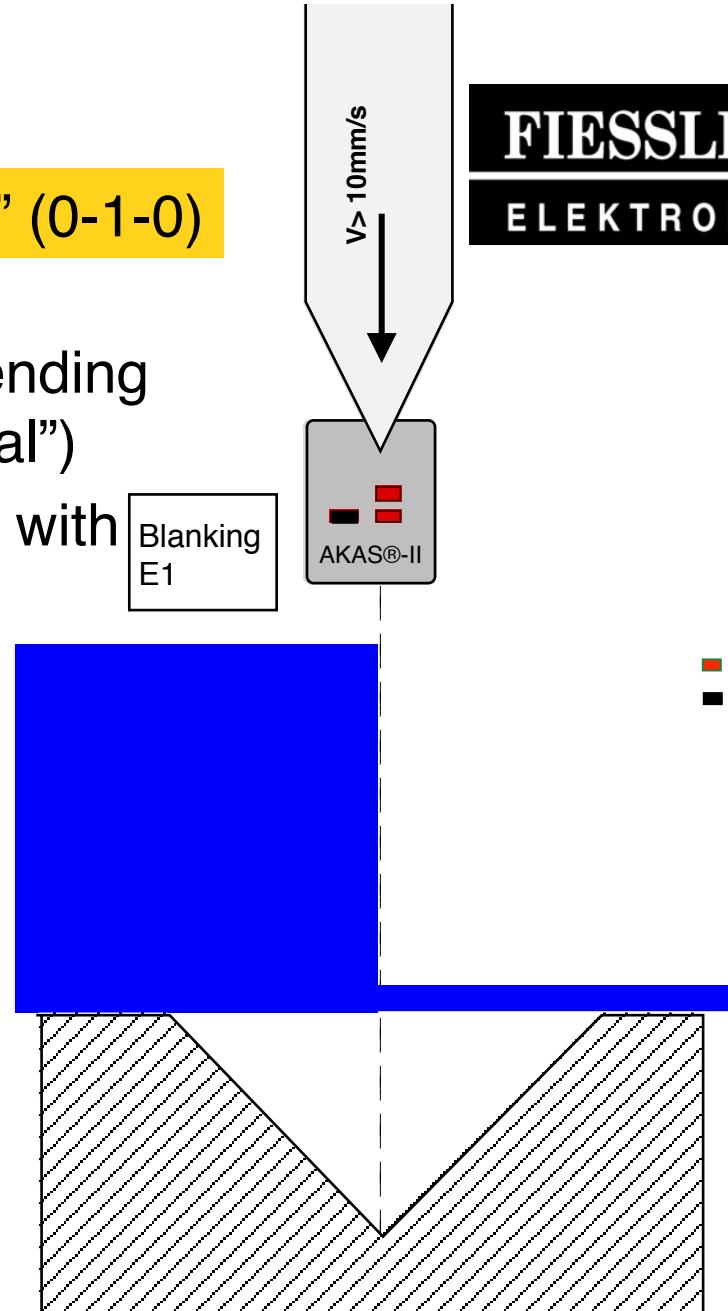
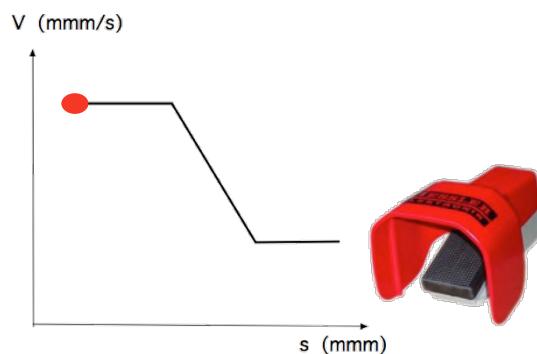
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- Selection of Box bending
function (“puls signal”)
- Start bending cycle with
foot pedal



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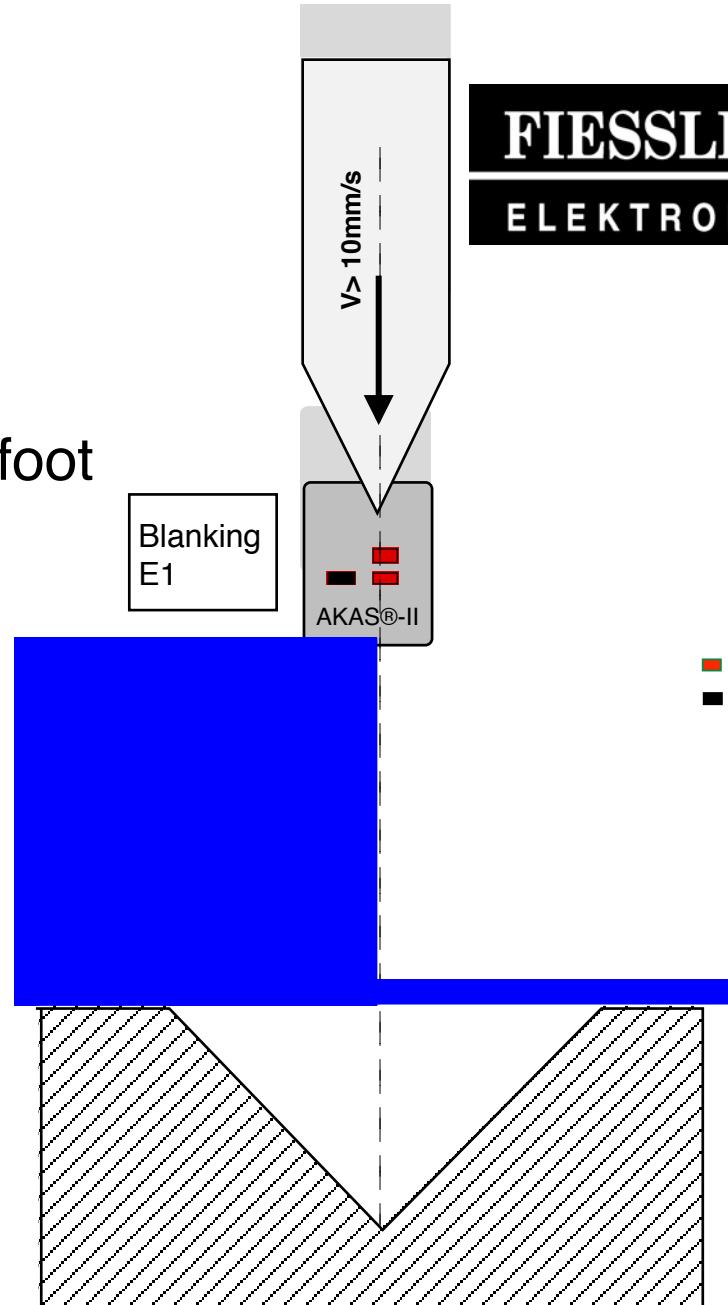
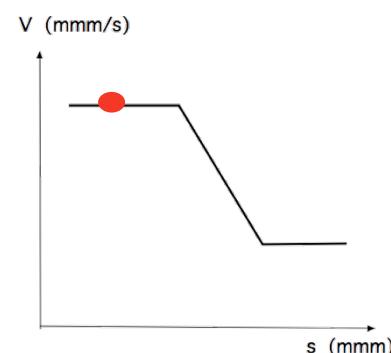
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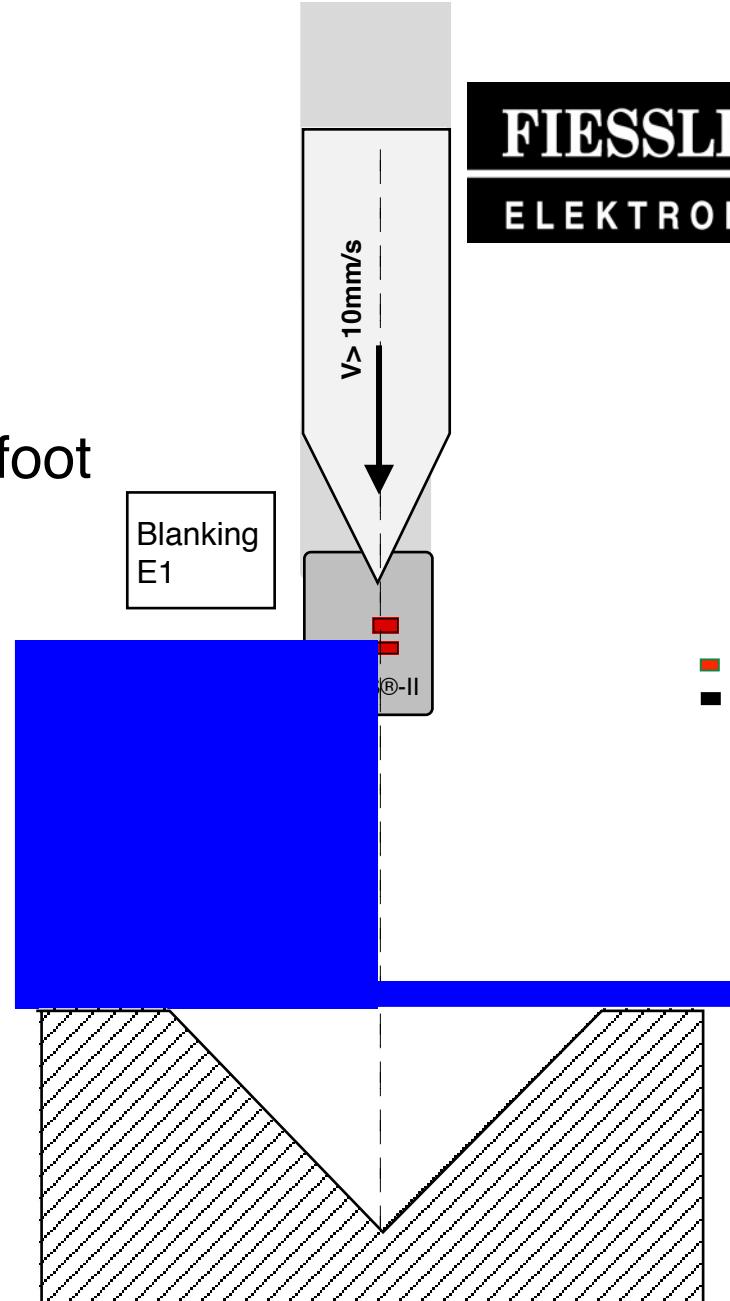
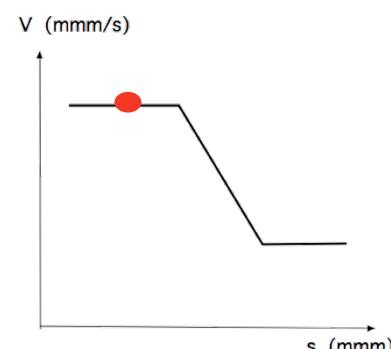
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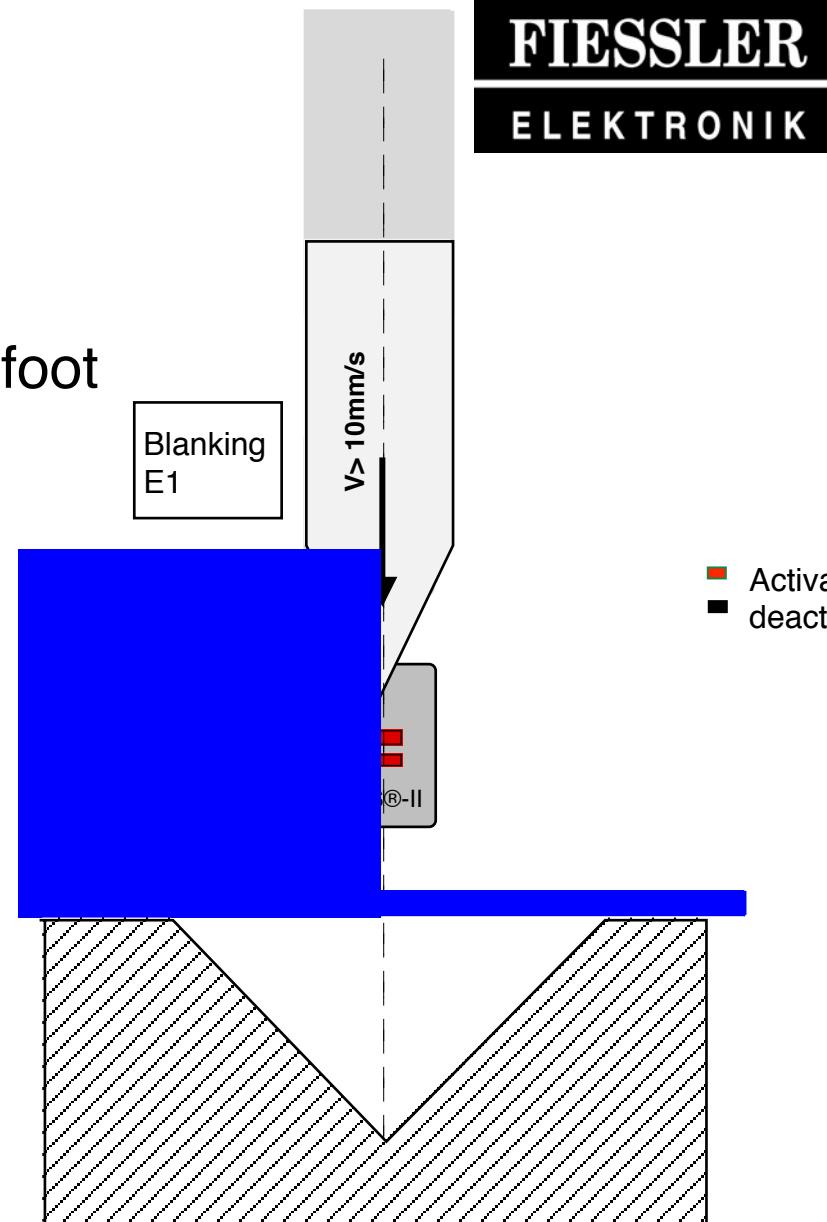
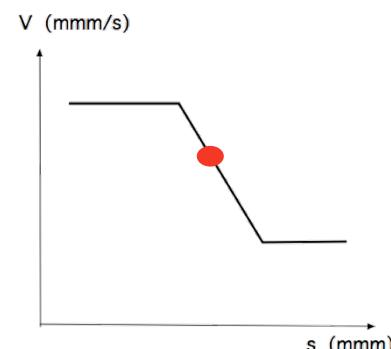
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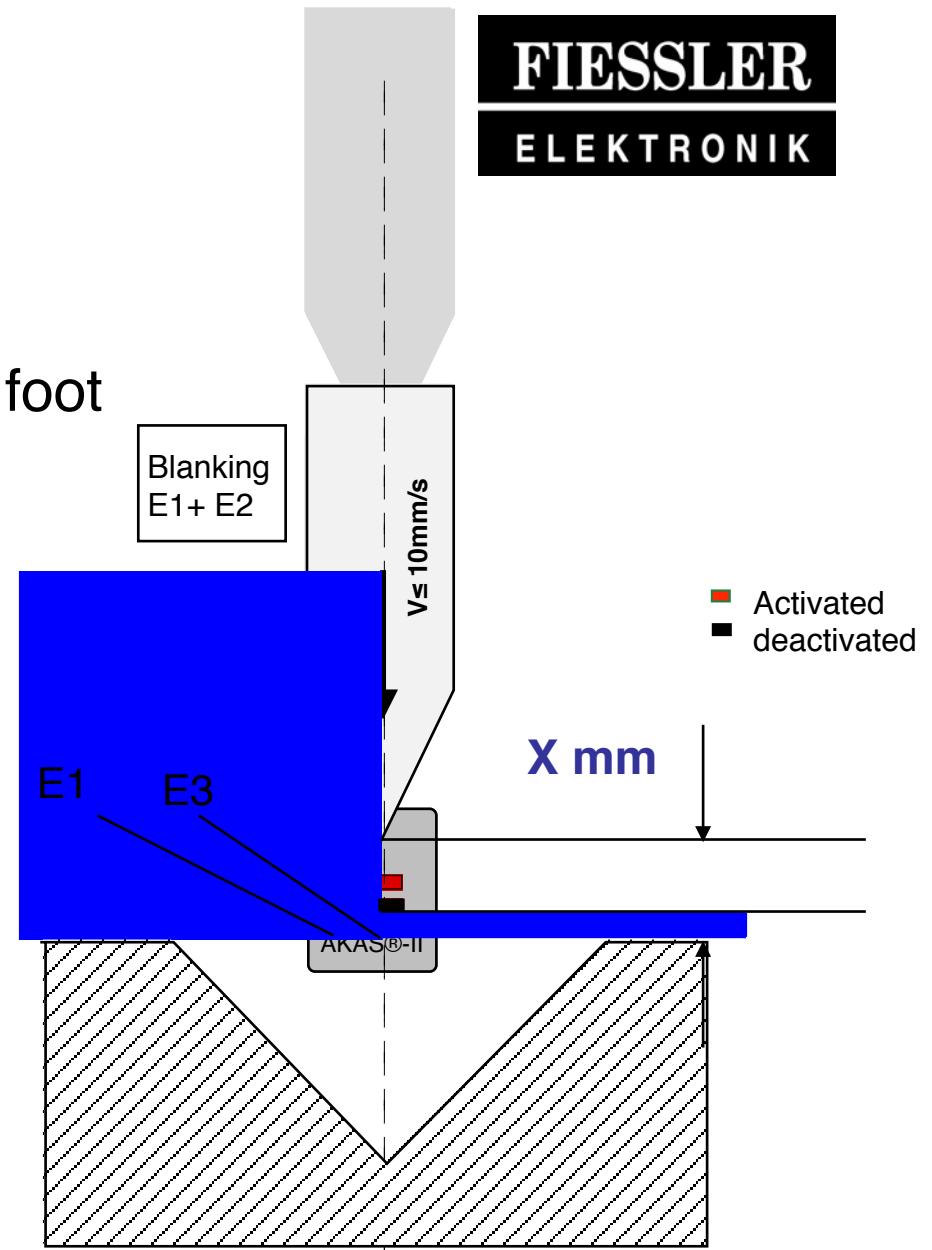
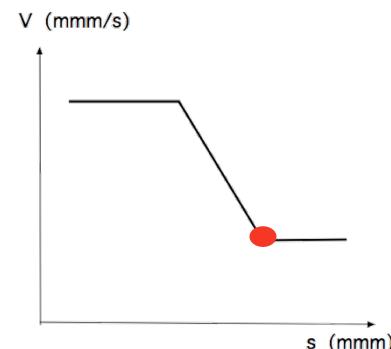
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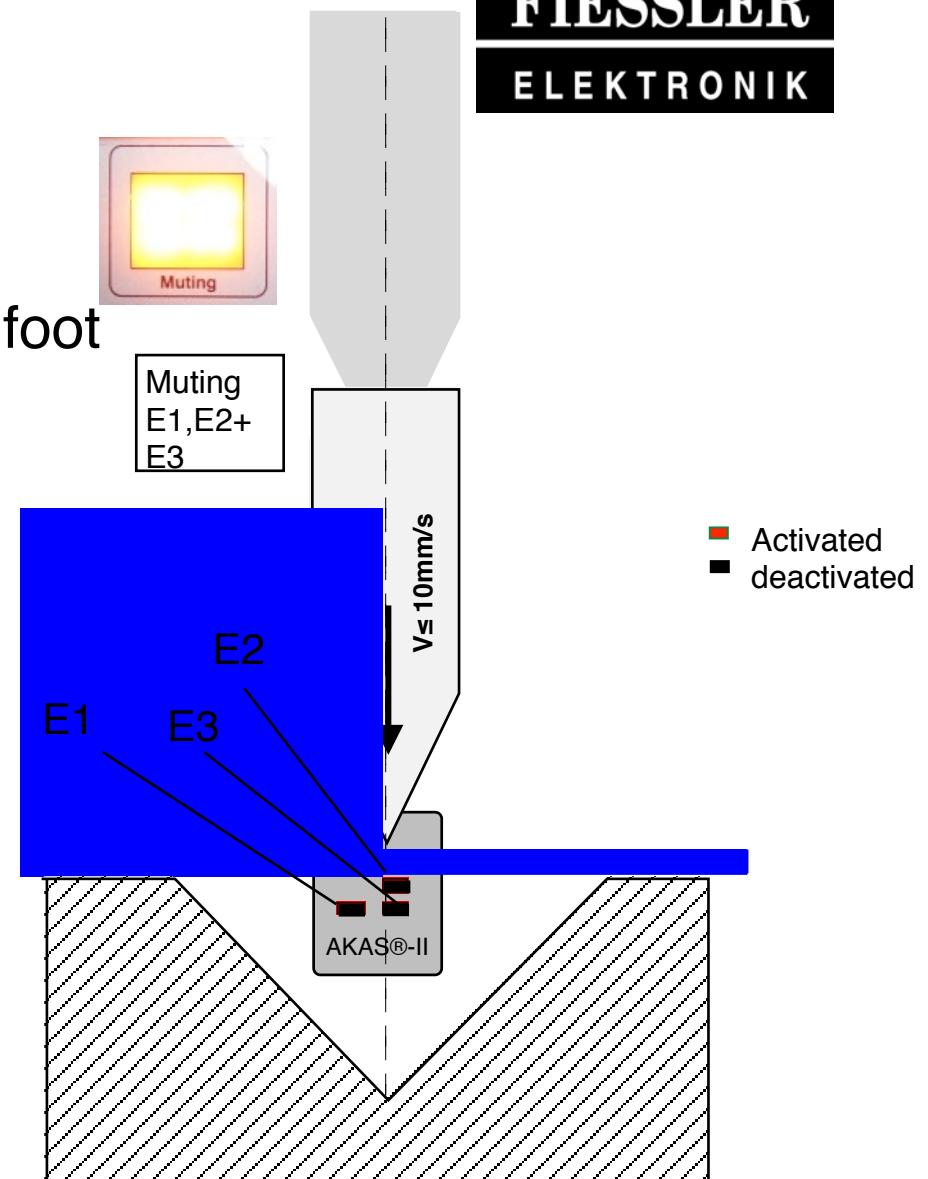
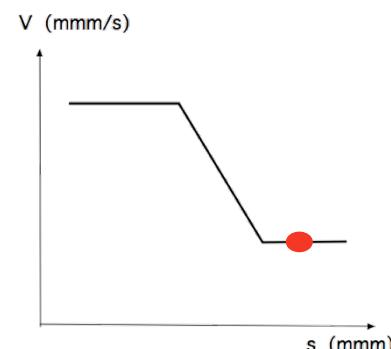
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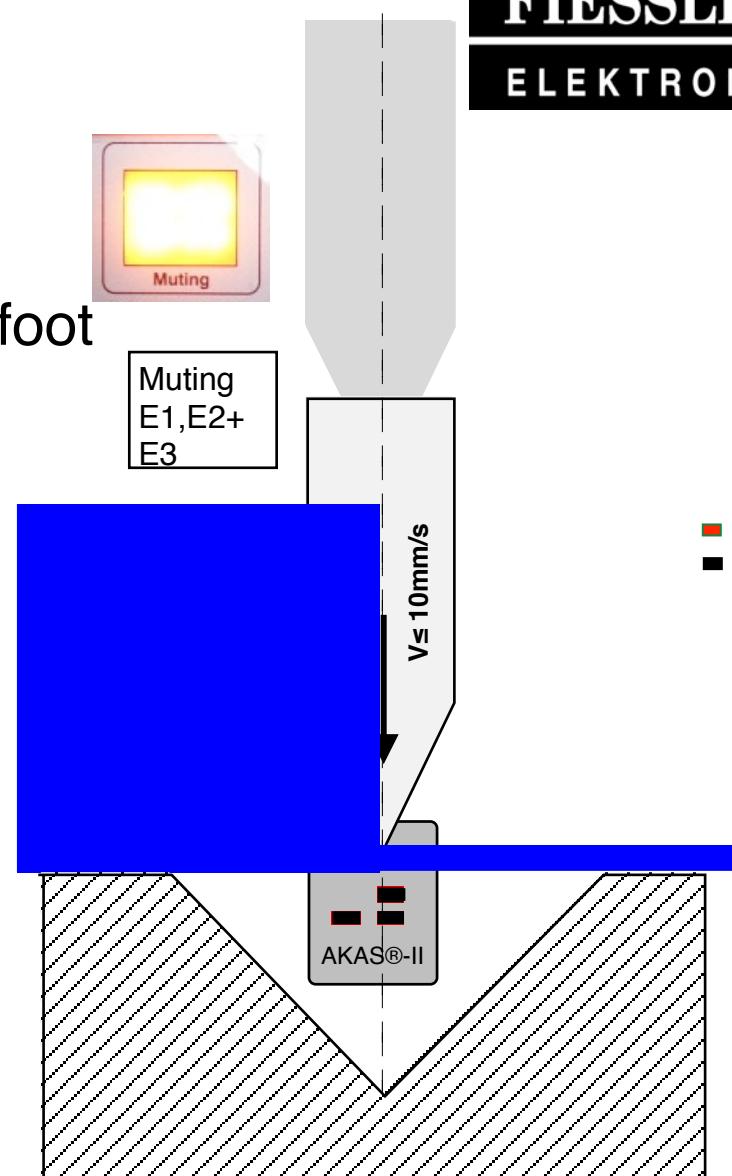
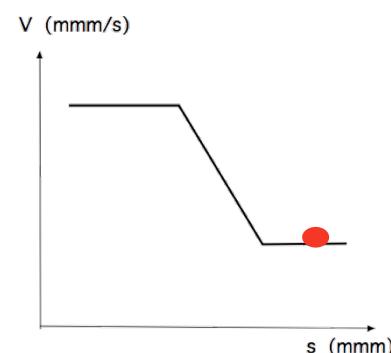
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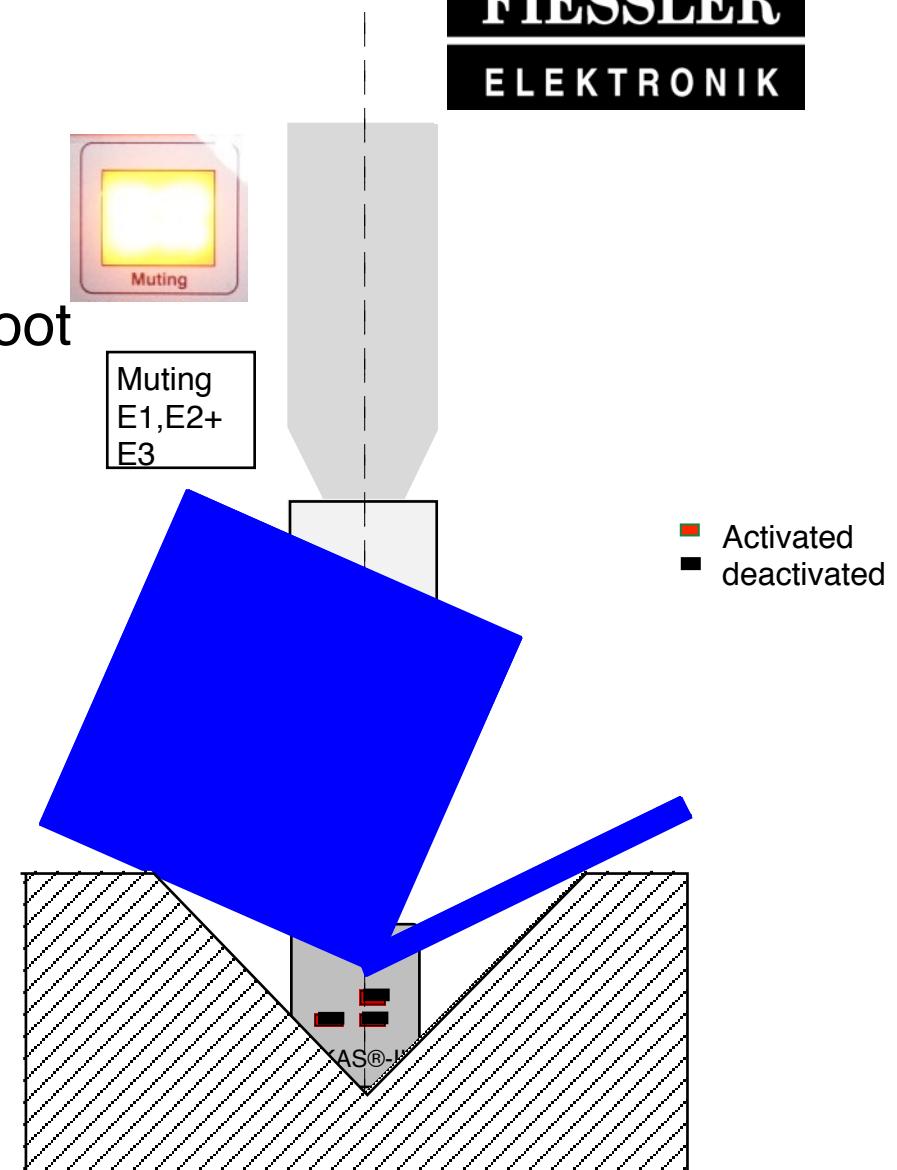
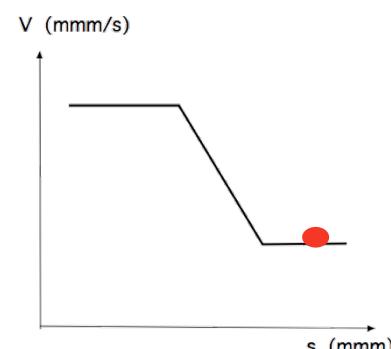
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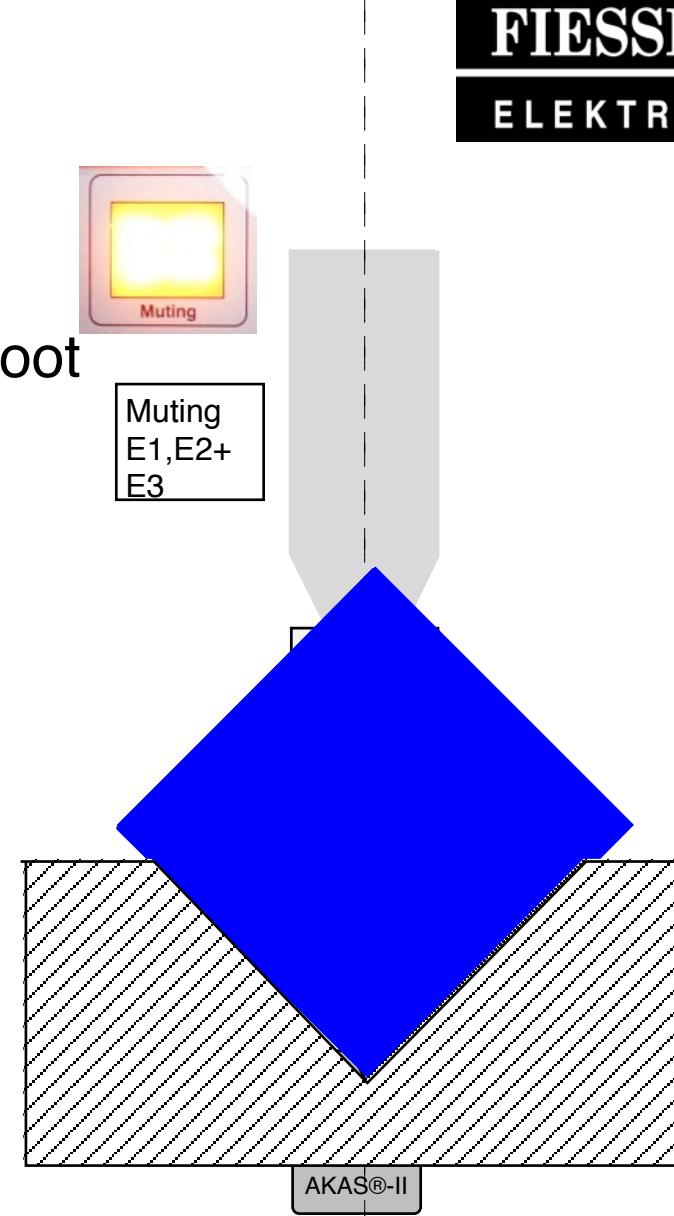
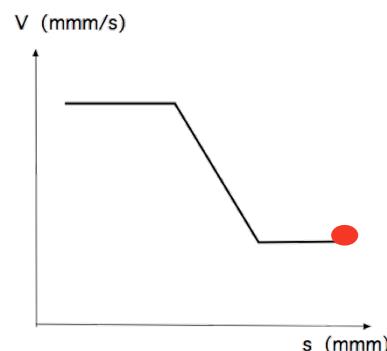
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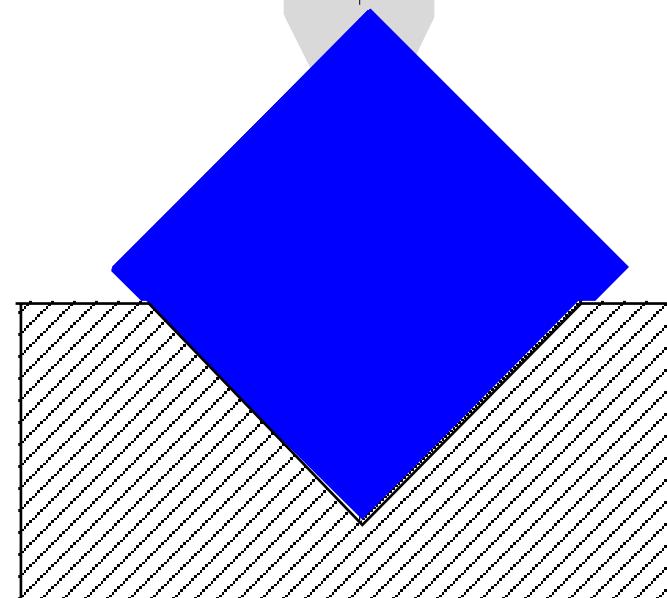
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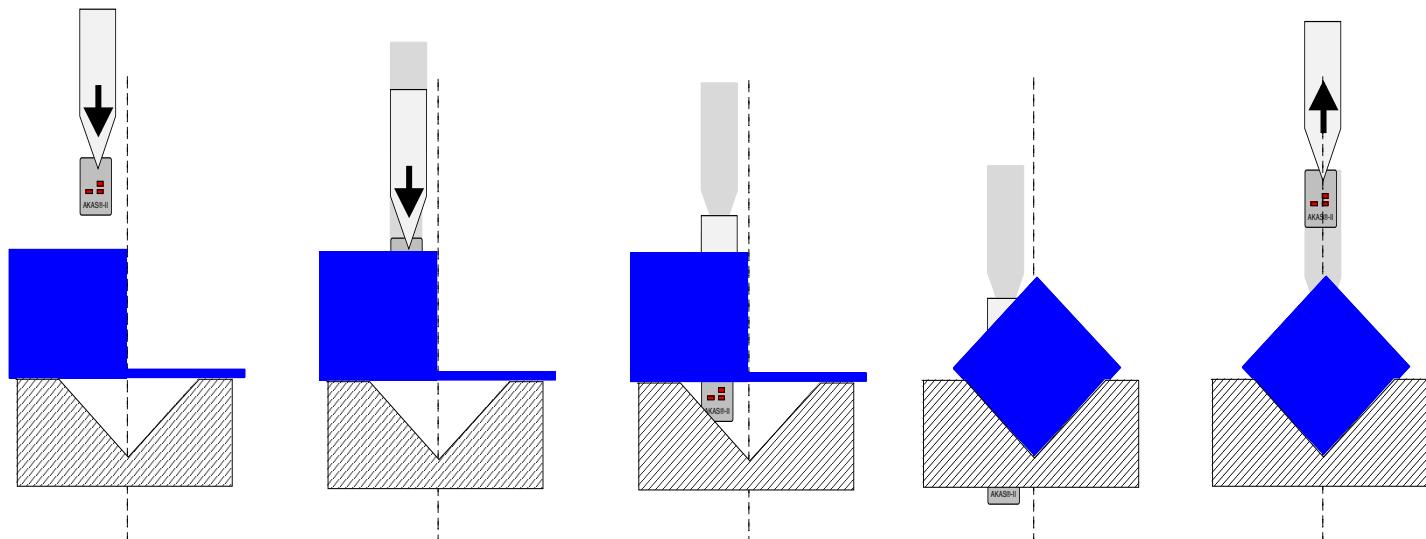
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➤ AKAS®

- ... needs no break in box bending cycle
- ... offers a high level safety for the operator
- ... will work with fast speed till minimum distance to sheet plates
- ... needs no special foot pedal sequences
- ... save a lot of time during the box bending function

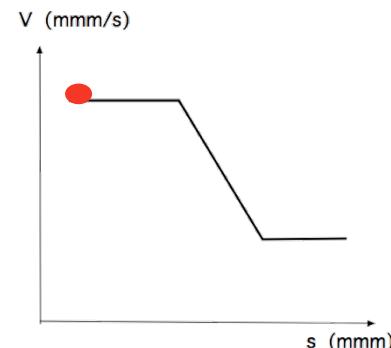
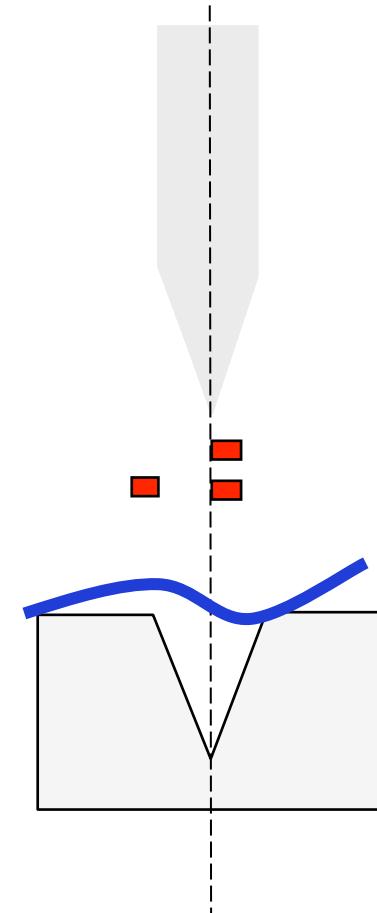
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- Output SGA = 1
- Start bending cycle with foot pedal



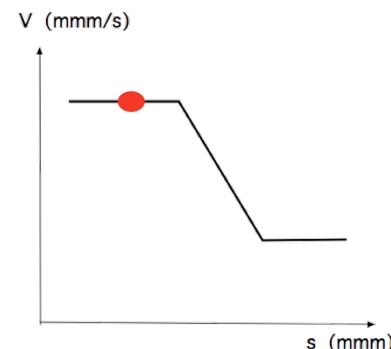
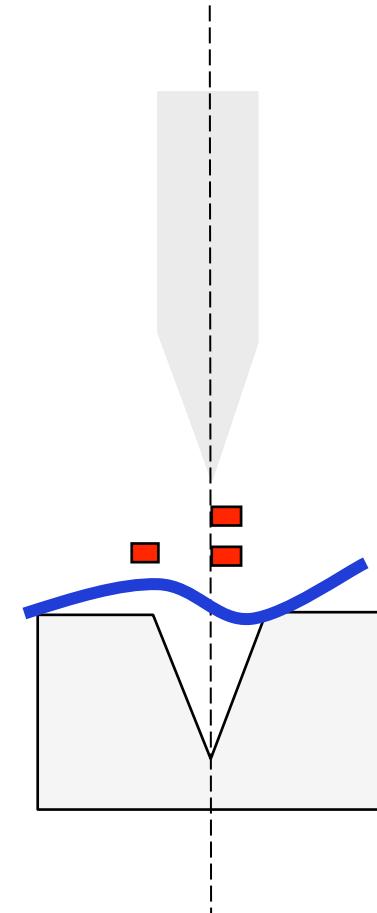
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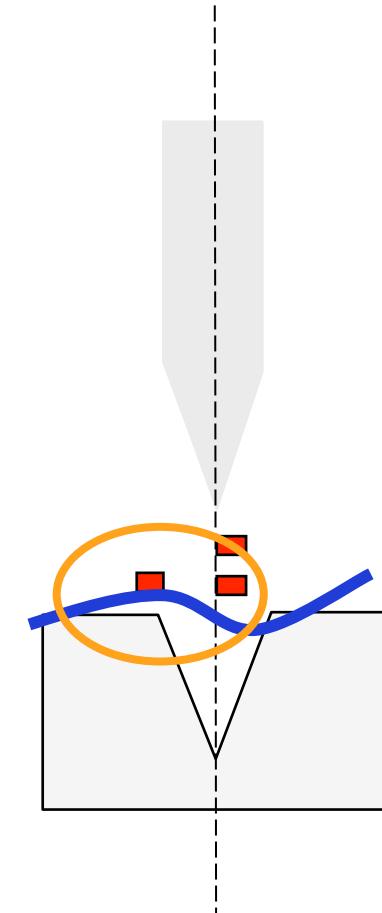
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- Output SGA = 1
- Start bending cycle with foot pedal
- STOP
- Loose foot pedal
- Output SGA = 0



AKAS® Bending of wavyly sheet plates (optional mode)

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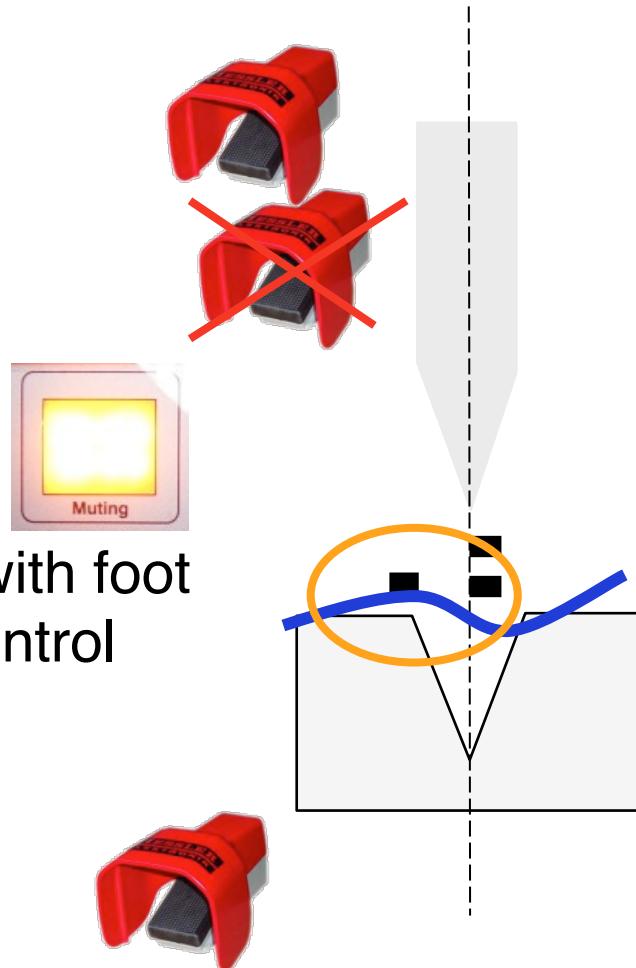
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- Loose foot pedal
- Output SGA = 0
- Muting lamp active
- Restart press cycle with foot pedal or two hand control device



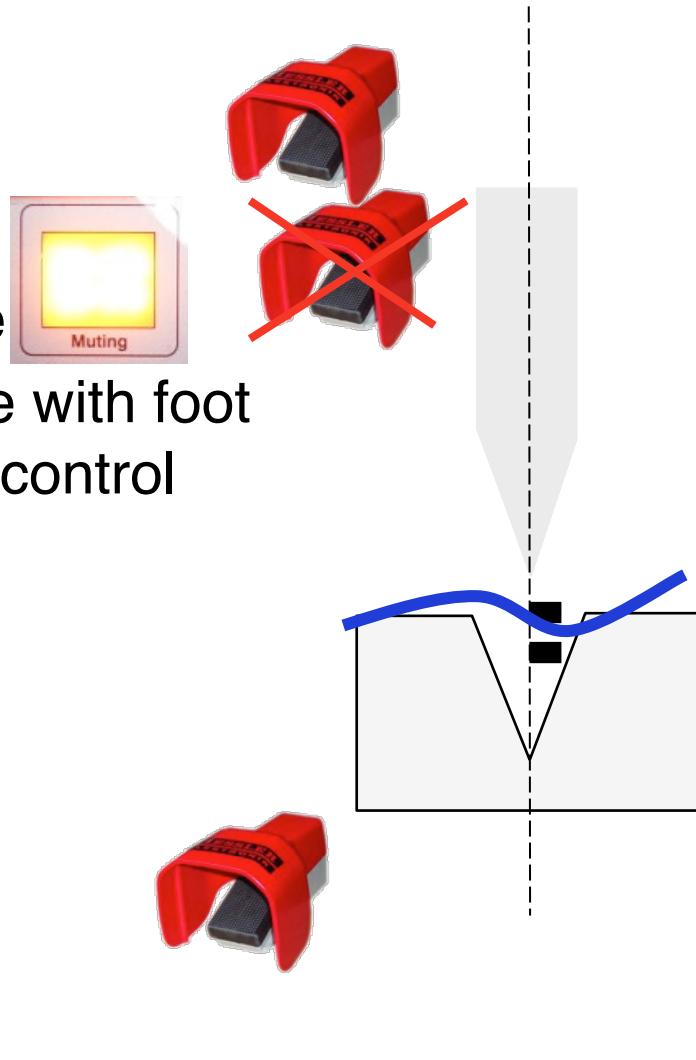
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- Loose foot pedal
- Output SGA = 0
- Muting lamp active
- Restart press cycle with foot pedal or two hand control device



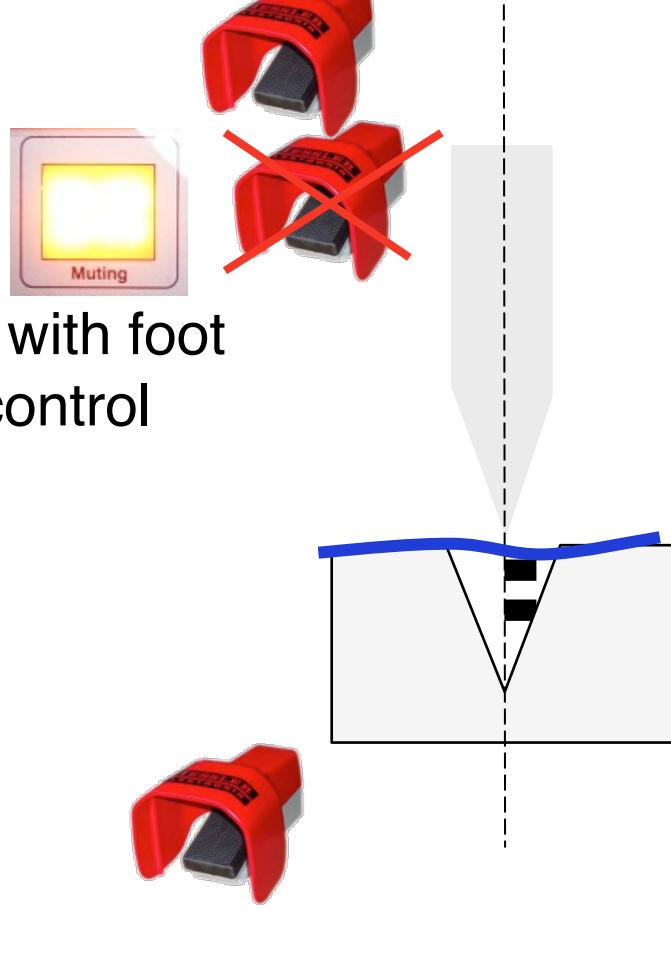
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- Loose foot pedal
- Output SGA = 0
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- Restart press cycle with foot pedal or two hand control device



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